



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-B-05
Job Sheet 197415



Part No: RBE350A94-3700-B-05

Job Qty: 24 pcs *25*

DAS
21
2:20

Part Name: Foot



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-B Rev. 6 IPP Rev. A 18.08.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	SL-2500Y - 1	24 pcs	9/2/19	9/2/19	1.00	4.00	SL-2500Y - 1	<i>SL 19-7-29</i>
130	QC 2	24 pcs	9/2/19	9/2/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	<i>SL</i>
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

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Container No: S200926



Part: RBE350A94-3700-B-05

Job No: 197415

Serial No/Batch: S200926

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/29/19

140 QC 8	24 pcs	9/2/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	JF 19-07-29
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
170 Outsource - 12 - Black Oxide	24 pcs	9/2/19		GRO002-VC	10
180 Packaging 2-1 - Receive - B4B	24 pcs	9/2/19	0.00 0.00	Packaging 2 - 1 - B4B	JF 2019-07-31
25 pcs JF				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	JF AUG 08 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

190 QC 6	24 pcs	9/2/19	0.00 0.00	Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	81
				QC 6 - 40	9-89
				QC 6 - 81	
200 Packaging 3-1 - Stock - B4B	24 pcs	9/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	24 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

AUG 09 2019

DAS
21
9-89

GA141B

AUG 09 2019

Part Op 120 - 1-Machine as per folio FC728 FOLIO REV: AA DWG REV: 7 2-Deburr

Descriptions: 130 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)

140 - QC8 Machining-4 (QC8- Inspect parts - second check)

170 - Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO 44161 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

180 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

190 - QC6 (QC6- All purchased or subcontracted products)

200 - Packaging3-1 (Identify as per dwg & Stock Location: _____)

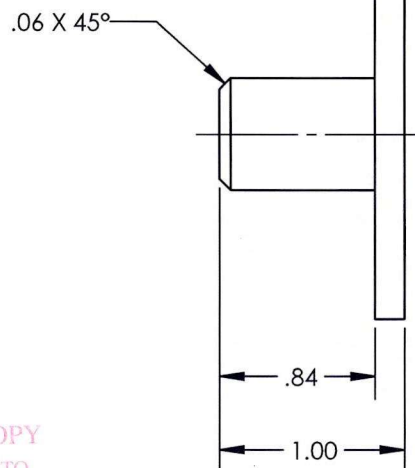
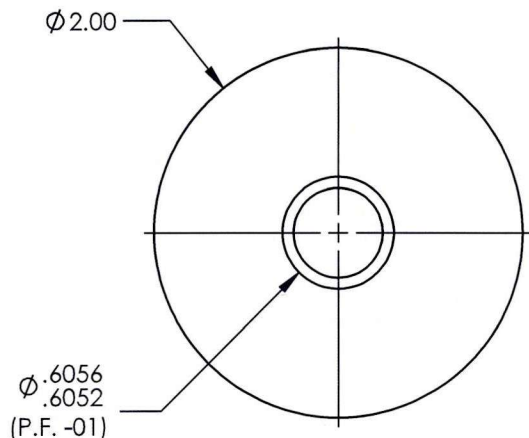
210 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1018R2.00	M1018R2.00	2.4000 ft (.1 ea)	120-SL-2500Y - 1	S172608 S037949
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-2500Y - 1	M1018R2.00	2	5	0
Part Specifications				
Specifications could not be found.				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		-05 CH'D DIM WAS Ø2.00 IS (Ø2.00), WAS Ø.586 P.F. -05 IS Ø.586 P.F. -01.	5/23/2014	DPD	RJC
6	16-0151	-05 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01), WAS (Ø2.00) IS 2.00, ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D, CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	2/24/2017	RJC	SM



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197415 MJS
19-07-08

Ø5

FOOT

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL SHORT BRACE ASSEMBLY	
DWG NO. RBE350A94-3700-B-05	REV 6
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012
SHEET 5 OF 5	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044161



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044161
PO Date: 7/31/19
Due Date: 8/8/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2019-08-01

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189231	RB6796941-201-4	Adapter -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/8/19	10 pcs	0 pcs	10 pcs	\$1.98/pcs	\$19.80
2	197493	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/8/19	8 pcs	0 pcs	8 pcs	\$2.40/pcs	\$19.20
3	197444	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/8/19	24 pcs	0 pcs	24 pcs	\$2.80/pcs	\$67.20



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PURCHASE ORDER

POHB044161



Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
4	197415	RBE350A94-3700-B-05	Foot Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/8/19	25 pcs	0 pcs	25 pcs	\$1.97/pcs	\$49.25	
25 X AUG 08 2019 												
5	197961	RBT18666-7	Bolt Plate -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/8/19	5 pcs	0 pcs	5 pcs	\$0.85/pcs	\$4.25	
5 X AUG 08 2019 												
Grand Total:											\$159.70	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/1/19 3:58 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021205-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

021205 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
05-Aug-2019		SPARTAKOS BOUNTOURIS				POHB044161				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir / Back Order
1	RB6796941-201-4 ✓ Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1		BLACK-OXIDE CH	10	10 ✓	0	0	0	
2	RBE350A94-2706-00-05 ✓ Rev.	RBE350A94-2706-00-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	8	8 ✓	0	0	0	
3	RBE350A94-3700-A-05 ✓ Rev.	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1		OXIDE-BLACK CH	24	24 ✓	0	0	0	
4	RBE350A94-3700-B-05 ✓ Rev.	RBE350A94-3700-B-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1		OXIDE-BLACK CH	25	25 ✓	0	0	0	
5	RBT18666-7 ✓ Rev.	RBT18666-7 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS		OXIDE-BLACK CH	5	5 ✓	0	0	0	

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07 2019

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07 2019

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

Quaxi